

Work Order ID 52637

October 5, 2009 10:41:54 AM

Page 1

Item ID: 41232-200-004-001

Revision ID: IR

Item Name: Reducer Tee Assembly

Start Date: 10/05/09 Start Qty: 6.00

Required Date: 10/12/09 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: *W*

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

41232-200-004

Rev IR

100

0.00



Lathe Conv

CONVENTIONAL LATHE

Memo

0.00

Conventional Lathe

1-Turn AN815-4J as per Dwg 41232-200-004 12-Deburr as Required.

110

0.00



Mill Conv

CONVENTIONAL MILLING MACHINE

Memo

0.00

Conventional Milling Machine

1-Drill as per Dwg 41232-200-001 12-Deburr

- Spot face 5/8 before drilling

120

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control



Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



SA 09/10/16

6 0

mult 09/10/20

6 0

mult 09/10/20

6 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52637

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Page 2

Item ID: 41232-200-004-001

Accept

Revision ID: IR

Item Name: Reducer Tee Assembly

Setup Start

Stop

Start Date: 10/05/09 Start Qty: 6.00

Required Date: 10/12/09 Req'd Qty: 6.00

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

B.A 09/10/20

QC

Memo

0.00

Quality Control

140

Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg 41232-200-004 11A/R
Batch: M108160

SS Rod

EL 9-10-21

(X6)

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

1-WELD INSPECTION 12-Pressure test as per Dwg 41232-200-004: 3-
Passivate Finish.

→ 10/10/22
PL 09/10/22
QC 5 inspect work to current step => 5/10/23 (X6) f

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NOTE: Date & initial all entries

Work Order ID 52637

October 5, 2009 10:41:55 AM



Item ID: 41232-200-004-001

Accept



Setup Start



Revision ID: IR

Stop



Item Name: Reducer Tee Assembly

Start Date: 10/05/09 Start Qty: 6.00



Cust Item ID:

Required Date: 10/12/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 364

0.00



Packaging

Memo

0.00

Packaging

9/10/23

[Signature]

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

9.10.27

mf 09-10-24

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

October 5, 2009 10:41:53 AM

Work Order ID: 52637

Parent Item: 41232-200-004-001RevIR

Parent Item Name: Reducer Tee Assembly

Comments:

Start Date: 10/05/09

Required Date: 10/12/09

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN815-4J		Purchased	No			100	Each	20.0000	6.0000			



union

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

104253

20

20

100

Each

0.0000

6.0000

AS1035J080812

Purchased

No



TEE

112901

6. *[Signature]*

6 *[Signature]*

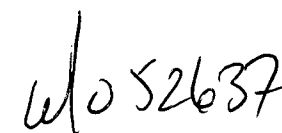
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				1	-005	UNION	MAKE FROM AN815-4J UNION					
				1	-003	REDUCER TEE	MAKE FROM BELL P/N AS1035J080812 or 110-080-120					
				-001	-001	REDUCER TEE ASSY						
NO. REQ'D PER ASSY					PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE		
LIST OF MATERIAL												
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						CHECK	D. MURPHY	5/24/02	REDUCER TEE ASSY			
						STRESS						
						PROJ. ENGR.			DWG. SIZE	C	SCALE	2:1
						HEAT TREAT						
-001 2 41232-000-001												
NEXT ASSEMBLY												
DWG. NO. 41232-200-004 SHT 1 OF 2					MOL	FINISH	Era Aviation, Inc.			REV. IR		

NOTES:

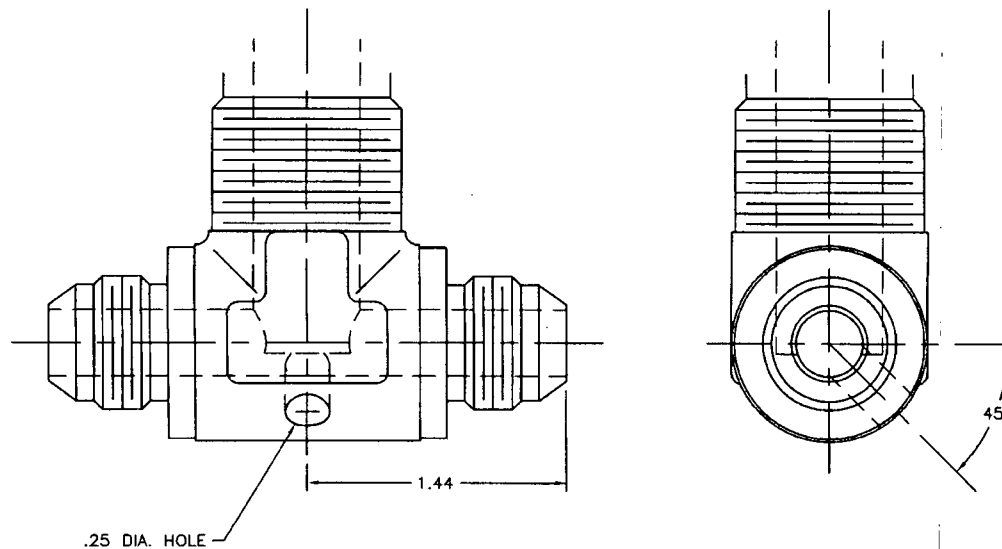
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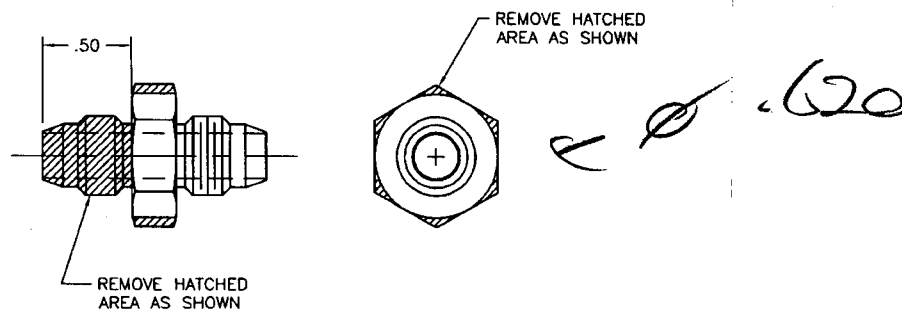
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-003 REDUCER TEE



-005 FITTING

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Era Aviation, Inc.

REDUCER TEE ASSY

SIZE
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QWS. NO.
 41232-200-004
 SHT 2 OF 2

REV.
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